Prime ABS 860 FR

Acrylonitrile Butadiene Styrene

Primex Plastics Corporation

Message:

Prime ABS 860 FR is an ignition resistant ABS with excellent process stability, high practical toughness and heat distortion temperature.
Applications:
Prime ABS 860FR may be used for interior applications such as appliance parts, transportation and electronics.
Processing:
Prime ABS 860FR has excellent thermoforming characteristics. It is extremely versatile in nearly all thermoforming operations from high volume, multi-station rotary machines to single station and shuttle presses. Pressure forming techniques have also been highly successful. It can be formed on wood, epoxy, ceramic and/or aluminum tools. The forming temperature has a range of 300 - 350°F. For best results the mold temperature should be 150-190°F. In some cases it is necessary to dry the sheet before forming.
Finishing:
Prime ABS 860FR can be screwed, drilled, routed, punched and die-cut with conventional tooling. Parts made with Prime ABS 860FR may be joined with machine screws, bolts, nuts, rivets, and spring steel fasteners. Thread- cutting or thread-forming screws are an economical means for securing separate joints. Formed parts may be joined with Methylene Chloride if maximum impact strength is not required. Press and snap techniques and sonic welding may also be used for the bonding of Prime ABS 860FR.
Please contact your Primex Plastics representative for more information on finishing, fabricating, or the thermoforming process.
Colors, Textures, Capabilities:
Prime ABS 860FR can be color matched to meet your specific requirements. Prime ABS 860FR is available in thicknesses from .060 - .400. Textures include Calf Grain, HC, RM, Seville, Levant II, FL/HC and Diamond Plate.

General Information			
Features	Good Processing Stability Good Toughness High Heat Resistance High Impact Resistance High Tensile Strength Low Temperature Impact Resistance		
Uses	Appliance Components Electrical Parts Electrical/Electronic Applications		
Appearance	Colors Available		
Forms	Sheet		
Processing Method	Thermoforming		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.18	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	12	g/10 min	ASTM D1238
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	98		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Yield)	41.2	MPa	ASTM D638

Flexural Modulus	2060	MPa	ASTM D790
Flexural Strength	54.9	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C)	200	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (0.45 MPa, Annealed)	82.8	°C	ASTM D648
Vicat Softening Temperature	92.8	°C	ASTM D1525
Flammability	**Nominal Value**		**Test Method**
Flame Rating			UL 94
> 1.50 mm	V-0		
> 2.49 mm	5VB		
Additional Information	**Nominal Value**	**Unit**	
Thermoforming Molding Temperature			
Forming Temperature	149 to 177	°C	
Mold Temperature	66 to 88	°C	

Recommended distributors for this material

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